



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3447-9

Job Sheet 173133



Part No: D3447-9

Job Qty: 8 ea

Part Name: Swing Arm



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 4/16/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV C SHEET 4 IPP A 05.08.26 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	4/14/18	4/14/18	0.00	0.00	Start Up Machining-2		SBL 18/04/12
100	Bandsaw	8 pcs	4/14/18	4/14/18	0.00	0.75	Bandsaw1		SBL 18/04/12
110	CNC Vertical Machining	8 pcs	4/14/18	4/14/18	0.08	5.37	HAAS1-3		SBL 18/04/12
130	QC	8 pcs	4/14/18	4/14/18	0.00	0.00	QC8 Machining-2		18/04/15
140	HandFinish	8 pcs	4/14/18	4/14/18	0.00	0.23	HandFinish1		SA 18-04/16
150	Powdercoat	8 pcs	4/16/18	4/16/18	0.00	0.22	Powdercoat5		BK 18-4-18
160	QC	8 pcs	4/16/18	4/16/18	0.00	0.00	QC3		CPC
170	Packaging	8 pcs	4/16/18	4/16/18	0.00	0.00	Packaging3-1		
180	QC21-SA	8 Ea	4/16/18	4/16/18	0.00	0.00	QC21		APR 19 2018

Part Op 100 - Cut blanks: 1.500" x 1.500" x 8.400" long

Descriptions: 110 - Machine as per Folio FA544 and Dwg B67-43001 Identify as D3447-9Dwg Rev ____ Folio Rev ____

150 - Mask inside holes as per Dwg D3447 prior to painting

M 138014 START: 2:00 OUT: 3:00 FINISH: 3:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6B1.500X1.500	7075 T6 Bar 1.500 X 1.500	5.6000 ft (.7 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6B1.500X1.500	6	0	0

FM138563 -> SO60361



Container No: S060369



Part: D3447-9

Job No: 173133

Serial No/Batch: S060369

Revision:

Inspector:

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Date: 04/12/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Swing Arm	8.020inches $\pm$ 0.030	8.050 7.990	8.02	
2	Swing Arm	7.075inches $\pm$ 0.005	7.080 7.070	7.074	
3	Swing Arm	0.380inches $\pm$ 0.030	0.410 0.350	0.380	
4	Swing Arm	0.375inches + 0.006 - 0.001	0.381 0.374	0.375	
5	Swing Arm	0.750inches $\pm$ 0.030	0.780 0.720	0.750	
6	Swing Arm	0.375inches $\pm$ 0.005	0.380 0.370	0.374	
7	Swing Arm	0.470inches $\pm$ 0.005	0.475 0.465	0.471	
8	Swing Arm	1.100inches $\pm$ 0.010	1.110 1.090	1.108	
9	Swing Arm	0.710inches $\pm$ 0.030	0.740 0.680	0.710	
10	Swing Arm	0.178inches $\pm$ 0.010	0.188 0.168	0.178	
11	Swing Arm	1.825inches $\pm$ 0.010	1.835 1.815	1.816	
12	Swing Arm	2.375inches $\pm$ 0.010	2.385 2.365	2.375	
13	Swing Arm	0.250inches $\pm$ 0.030	0.280 0.220	R. 0.250	
14	Swing Arm	0.130inches $\pm$ 0.030	0.160 0.100	R. 0.130	
15	Swing Arm	3.700inches $\pm$ 0.010	3.710 3.690	3.700	
16	Swing Arm	0.250inches $\pm$ 0.030	0.280 0.220	0.253	

Plex 2/26/18 12:52 PM Dart. Gagnon.Michelle